

Date: Tuesday, 1/3/2006 4:20:28 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE SPACER		
Job Number	: 25379					
Estimate Number	: 11063					
P.O. Number	: N/A			Part Number	: D2935	
This Issue	: 1/3/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D2935 REV A	
First Issue	: N/A		Type	: MACHINED PARTS		
Previous Run	: N/A			Project Number	: N/A	
Written By	: See COMMENT BELOW			Drawing Revision	: A	
Checked & Approved By	: See ABOVE USER & DATE			Material	: N/A	
Comment	: Est A 00.06.06 New Issue EC			Due Date	: 1/28/2006	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S080	5052-H32 .080 Sheet	
		Comment: Qty.: 0.0532 sf(s)/Unit Total : 2.1294 sf(s) Material: 5052-H32/H34 (QQ-A-250/8) 0.080" Thick Batch M19052	(40) J.L 06.02.04
2.0	SHEAR	SHEAR	
		Comment: SHEAR 1 blank makes 4 parts Blank: 7.90" x 3.70" (+0.030" - 0.000")	J.L 06.02.04 (40)
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio FA073 Tumble Deburr any rough edges after tumbling → C/A N/A	J.L 06.02.04 (40)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.L 06.02.04 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



(40)

Comment: SECOND CHECK

MS

06/03/04

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06-03-17

(40)

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

(40)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

S+398

PC 6/3/21 (40)

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(40) 06/03/23

Job Completion



U 06-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

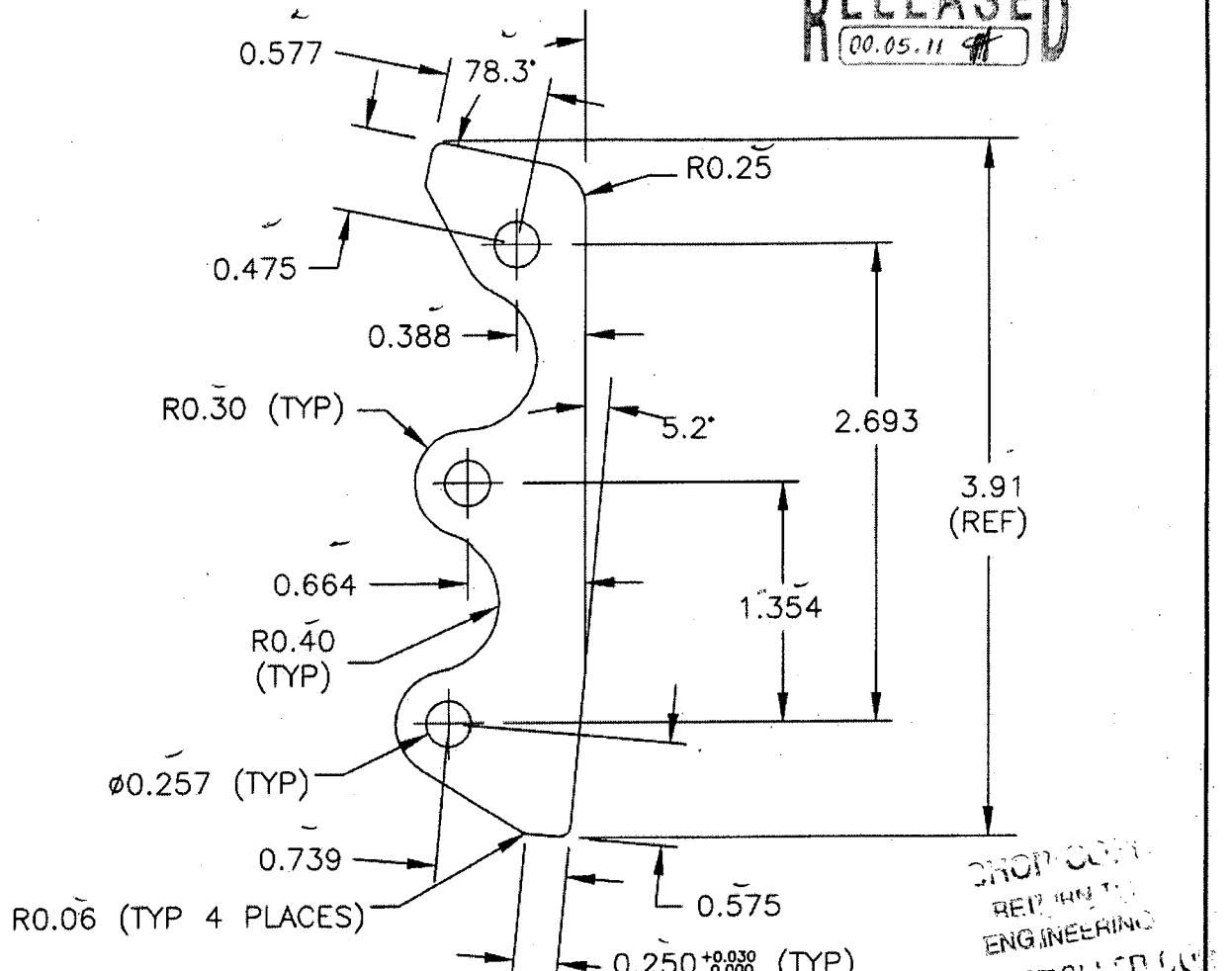
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2935	REV. A SHEET 1 OF 1
DATE 99.11.02	TITLE SADDLE SPACER		SCALE 1:1
A	99.11.02	NEW ISSUE	



MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.080 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL SHARP EDGES 0.010 TO 0.020

DART AEROSPACE LTD	Work Order:	25379
Description: Saddle Spacer	Part Number:	D2935
Inspection Dwg: D2935 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article

1

Prototype

Measured by:	J.L	Audited by:	MS	Prototype Approval:	N/A
Date:	06-02-04	Date:	06/02/04	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	